

Work Order ID 76054

76054

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Thursday, November 03, 2011 4:16:38 PM

Item ID: D3773-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Headrest Assembly
 Start Date: 11/4/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/9/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-11-03 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3773	Rev B								

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773 ****take dowel pin out before welding****
 2- weld as per dwg D3773 QSI004
 316 S.S. Welding Rod Batch: M114509
 3- if necessary grind interior of D3773-3 leg flush after welding

11-11-3 (24)

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

11-11-04 (49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							<i>Pl 11-11-04</i> <i>(4x)</i> <i>Ø</i>
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <i>SP205A</i> Memo	0.00 0.00							<i>SP 11-11-04</i>
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/11/11</i> <i>AD</i>

11/11-04
(4)

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Picklist Print

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Work Order ID: 76054

Parent Item: D3773-041

Parent Item Name: Headrest Assembly

Start Date: 11/4/2011

Required Date: 11/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-21 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3773-1 Adapter		Manufactured	No			110	Each	13.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA024		13							
				62090		2							
				62721		4							
				69942		7							
D3773-3 Leg		Manufactured	No			110	Each	10.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST250		10							
				62742		6							
				69944		4							

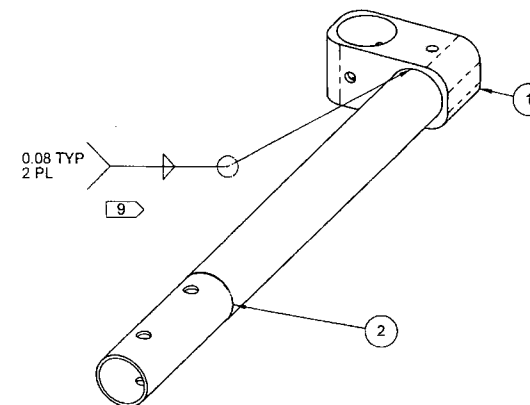
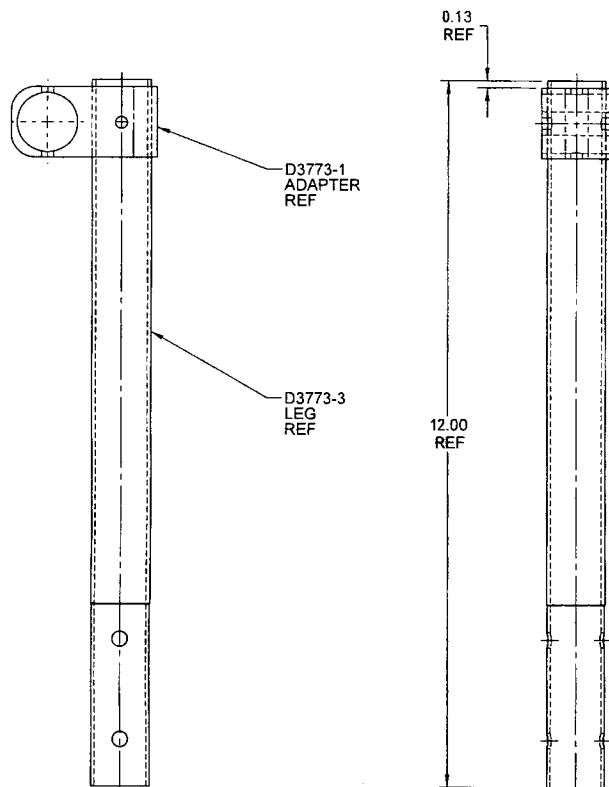
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	HS		
CHECKED	HS		
MFG. APPR.	HS		
APPROVED	HS		
DE APPR.	HS		
DATE	08.06.24		

RECEIVED
08.06.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3773**
REV. B
SHEET 1 OF 3
TITLE **HEADREST ADAPTER**
SCALE NTS

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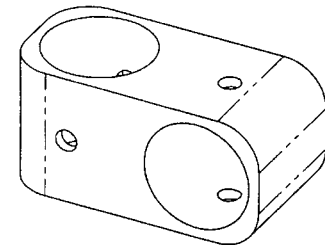
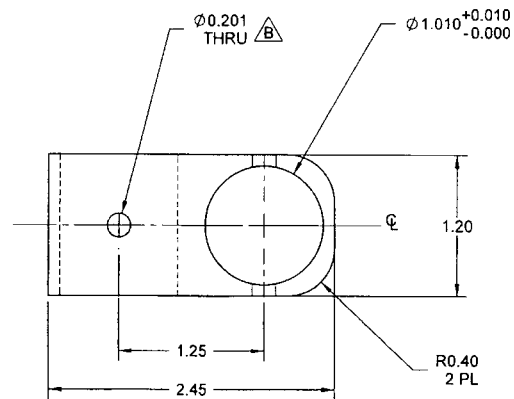
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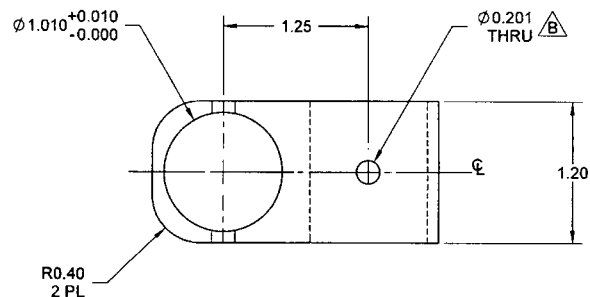
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76054



D3773-1 ADAPTER

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
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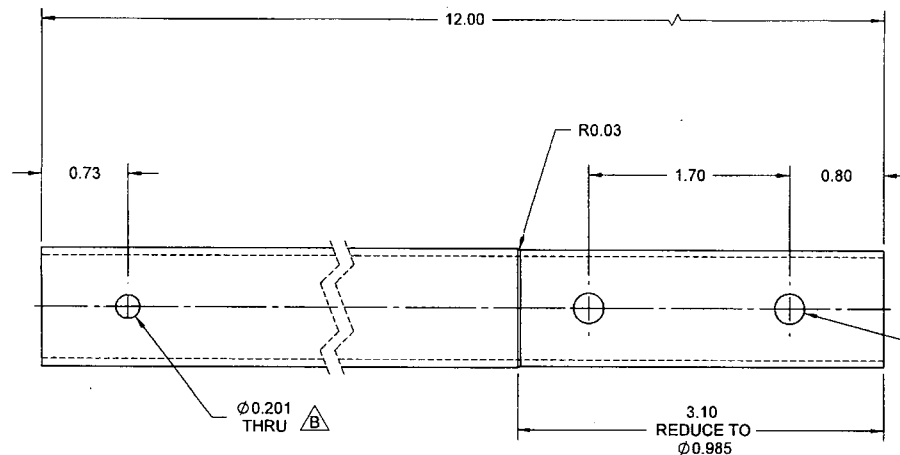
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

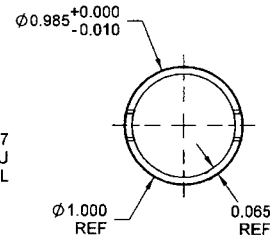
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D3773-3 LEG



7654

- NOTES:
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3773	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HEADREST ADAPTER	NTS
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